

Work Order ID 61145

Tuesday, August 10, 2010 8:34:18 AM



Page 1

Item ID: D206-628-024

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step RH

Stop



Start Date: 8/11/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-8-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

0.00

for BG 10-8-25

110



Pick Kit

0.00

10/8/20 (4)

Packaging

Packaging

Memo

0.00

120



QC4- 100% Inspect kits for completeness

0.00

4
10/8/20

QC

Quality Control

Memo

0.00

*- strips already in boxes w/ paper work,
- kits separated for pkng in boxes,*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

0.00

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-628-024
□ Location: 71 □ PPP Rev: G

140



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

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Picklist Print

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Work Order ID: 61145



Parent Item: D206-628-024



Parent Item Name: Heli-Access-Step RH

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A 		Purchased		No		120	Each	1,889.000	3	12			

BOLT

Location	Loc Qty	Loc Code
ST350	1889	
114108	14	
114416	12	
114523	2	
114941	861	M114941
115300	1000	

AN4C14A



Bolt

Purchased	No	120	Each	89.0000	4	16	
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Location	Loc Qty	Loc Code
ST358	89	
111902	89	M111902

AN4C15A



Bolt

Purchased	No	120	Each	124.0000	8	32	
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Location	Loc Qty	Loc Code
ST358	124	
111819	1	
113595	11	
113603	10	
114330	2	
114442	50	M114442 20
114523	50	M114523 70

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Parent Item: D206-628-024



Parent Item Name: Heli-Access-Step RH

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

AN960C10

NAS1149C0363 R

Purchased

No

120

Each

0.0000

3

12



M113824

CD

WASHER

AN960C416L



Purchased

No

120

Each

820.0000

24

96



h

WASHER

Location	Loc Qty	Loc Code
----------	---------	----------

FG	44	
104925	44	
ST346	776	
106785	38	
107008	10	
112794	287	
112828	400	M112828
69220	41	

D2731-7



Mounting Lug

Manufactured

No

120

Each

83.0000

4

.16



h

Location	Loc Qty	Loc Code
----------	---------	----------

ST470	83	
52330	35	52330 11X
55773	8	
59202	40	59202 5X

D2732



Rubber Extrusion

Manufactured

No

120

f

324.9310

1

8



h
118/25 (4)

X8 Ø 3.0" 10m
(per kit)
S10/08/25

Location	Loc Qty	Loc Code
----------	---------	----------

ST412	324.931	
56516	324.931	56516

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli-Access-Step RH

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

D2842-042



Step Assembly RH, 206 Float

Manufactured

No

120

Each

0.0000

1

4

61154

10/11/10

D2844-1



Arm

Manufactured

No

120

Each

16.0000

2

8

B61158

D2844-3



Arm

Manufactured

No

Location

ST265

Loc Qty

16

16

Loc Code

10.0000

1

52030 3X

4

D3394-043



Lug Assembly

Manufactured

No

Location

ST265

Loc Qty

10

10

Loc Code

65.0000

4

50820 16

Location
ST475
45365
52331
55772
Loc Qty
65
9
45
11
Loc Code
45365
52331

45365
52331
3X
134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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**5.2 D206-628-013/-014/-023/-024/-033/-033 FLOAT COMPATIBLE DART HELI-
ACCESS-STEPS™ PARTS LIST**

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	AN960C10	WASHER
24	24	24	24	24	24	AN960C416L	WASHER
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE